Quality Control

		Dorev	64382	· · · · · · · · · · · · · · · · · · ·							
Work Order II November 30, 2009 1		24							÷		Page
Item ID: D360	02-1			Accept					Setup Stai	t	
Revision ID: B Item Name: Angle	e	<i>t t</i>							Sto	р	
_	2/2009	Start Qty: 9.00 Req'd Qty: 9.00			Cust Item J.	D :					
	cess Plar	n:	Date 14-30	ノ Tooling:	Da	ite:			Run Stai	t	
	.		Date:			ite:			Sto	P	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D3602	Rev	B '									
Waterjet FLOW CNC Waterjet			per Dwg D3602 □ Dwg R f necessary	0.00 0.00 ev: & □Prog Rev:	<u></u>		•	R	<u>, 412-</u> ,	·	(II)
110		QC2- Inspect parts of	ff machine FAI/FAIB	0.00							
QC Quality Control		Memo		0.00				IB	. 9 <u>-13-</u> 3		
120 		QC8- Inspect parts - :	second check	0.00	orlizloz			(All) Ø		

Dart Aerospac	e Ltd
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W/O:			V	VORK O	RDER CH	ANGES	3		··· <u></u> -		
DATE	STEP	PRO	CEDURE CH	HANGE			Ву	Date C	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					•						
			· · · · · · · · · · · · · · · · · · ·			*					
Part No		PAR #:									
	R	esolution:								_ Date: _	
NCR:		V	VORK OR	DER NO	N-CONFO	DRMAN	CE (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	••	ive Action tion Descrip Chief Eng	Section I ption	Sign & Date	Verificati Section (Approval Chief Eng	Approval QC Inspector
			·								
					•	÷					•

Work Order ID 54124

November 30, 2009 12:51:11 PM



Page 2

Item ID:

D3602-1

Accept

Setup Start



Revision ID: Item Name:

Angle **Start Date:**

В

Start Qty: 9.00 01/12/2009

Cust Item ID:

Stop

Required Date: 07/12/2009

Req'd Qty: 9.00



Customer:

Reference:

Approvals:

Process Plan: Date:

Tooling:

Date:

Draw

Rev.

Plan

Code

Run

Start



QC: _____ Date: ___

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop



Sequence ID/ **Work Center ID**

130

Small Fab Small Fab

Small Fab

Operation

Description

Form as per Dwg D3602

Number

Draw

=7 Mil w/11/29

Reject Qty

Reject Insp. Number Stamp

140

\ Quality Control

QC5- Inspect part completeness to step on W/O

Accept

Oty

150

Packaging

Packaging

Identify as per dwg & Stock Location:



Memo

Memo

0.00

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Dart Aerospace Ltd

W/O: WORK ORDER CHANGES									
DATE	STEP	Ву	Date	Qty	Approvai Chief Eng / Prod Mgr	Approva QC Inspector			
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ė		·				İ			
		٧.		*					

Part No: D3602-1 PAR #: Fault Category: Small Fab NCR Yes No DQA: Date: 10.12-02

Resolution: Scrap QA: N/C Closed: Date: 10.12-02

	1	1 Description of NE				Varitication	Annroval	Annroval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
9/12/2	130	· Durking Forming it was Round that a "crack" was in through out the Bon Beno Rudius on the out side.	posture	- no grain Drectin in Duy - Right RADIUS in Port none of the other Park have this occurry	Na	Splan	position	1012-02
		2. Part looks like the mot grain is opening up During Bending R.C. process.	psime	- SCAP AND DESTU No Replace - use for A template / ciclent: for us reference culy	SB		Josuus.	5)
,								

Work Order ID 54124

В

Angle

Page 3

November 30, 2009 12:51:11 PM

Required Date: 07/12/2009

Item ID:

D3602-1

Accept



Setup Start



Stop

Item Name: **Start Date:**

Revision ID:

01/12/2009

QC:

Start Qty: 9.00

Operation

Description

Req'd Qty: 9.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Date:

Tooling:

0.00

0.00

SPC (Y/N):

Set Up/

Run Hours

Date:

Run Start

Stop

Sequence ID/

Work Center ID

160

Memo

QC21- Final Inspection - Work Order Release

Draw Number

Draw Rev.

Date:

Plan Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

MR 10-11-29

Quality Control

Dart Aerospa	ce Ltd
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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		,	3 pr - Mades - Calv - T.	•*				<u>. </u>				
						ļ						
						ļ						
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	\:	Date:				
÷	R	lesolution:	Disposition	n:	QA: N/C Clo	osed:		Date: _				
NCR:		1	WORK ORDI	ER NON-CONFORMA	NCE (NCR)						
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval			
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector			
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Picklist Print

November 30, 2009 12:51:17 PM

Work Order ID: 54124

Parent Item:

Comments:

D3602-1RevB

Parent Item Name: Angle



Start Date: 01/12/2009

Required Date: 07/12/2009

Page 1

Start Qty: 9.00

Required Qty: 9.00

B9-12-2

Component Item ID/	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	323.4471	5.5421	6.7736		
											B9-12-3	1

304/316 .040 Sheet

Warehouse	Loc Qty	Loc Code		
Location			•	
Main Warehouse				
MAT	323.4471158			_
110076	1.37053684			
112567	38.0765789			
112885	83.1578			
113062	175.8422		•	
113077	25		- 113077	-

Dart	Aer	osp	ace	Ltd
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W/O:			٧	VORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CI	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	tegory:	_ NCI	R: Yes	No DQ	A:	Date:	
	Re	esolution:	Disposi	ion:	_ QA	N/C CIC	sed:		Date: _	
NCR:			WORK OR	DER NON-CONFORMA	ANCE	(NCR				
DATE	STEP	Description of NC	,	,	ion B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	54124
Description: Angle	Part Number:	D3602-1
Inspection Dwg: D3602 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.25	+/-0.030	36.75).345	6			
2.348	+/-0.010	2,345)se			
R0.13	+/-0.030	.13	ig.			
			<u> </u>			
					·	

Measured by:	B	Audited by:	5	Prototype Approval:	N/A
Date:	9-12-2	Date:	09/17/02	Date:	N/A

Rev	Date	Change	Revised by	App/oved
Α	09.05.27	New Issue	KJ KJ	

36.25 REF R347 REF B 3.05 AC1-1 D3602-1 ANGLE (MAKE FROM D3602-1F)

1 2.348 **D3602-1F FLAT PATTERN**

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK, PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFY WITH DART P/N "D3602-1" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.97 lbs

						. 1
В	ADDED ROUNDED SHAPE: R347 REF AND 3.05; 2.348 WAS 2.328. REF: NCR#09-014			МВ	09.02.02	
Α	NEW ISSUE			MB	07.02.20	
REV.	DESCRIPTION			BY	DATE	
DESIGN	DART AEROSP		ACE LTD			
DRAWN			HAWKESBURY, ONTARIO, CANADA			
0,120.120		4	DRAWING NO.		REV. B	
		$\overline{}$	D3602	•	SHEET 1 OF 1	
APPRO	VED	IN.	7	TITLE		SCALE
DE APP	APPR ANGLE		ANGLE		NTS	
DATE 09.02.02				COPYRIGHT © 2007 BY DART IN THIS DOCUMENT IS FRINKTE AND COMPIDENTIAL AND IS SUPPLE NOT 70 BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATION OF THE PROPERTY O	DON THE EXPRES	IS CONDITION THAT IT IS

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